

Date: Monday, 1/7/2008 3:38:38 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 36634		
Estimate Number	: 11178		
P.O. Number	: <u>N/A</u>	Part Number	: D32931
This Issue	: 1/7/2008	S.O. No.	: <u>N/A</u>
Prsht Rev.	: NC	Drawing Number	: D3293 REV A
First Issue	: <u>N/A</u>	Project Number	: N/A
Previous Run	: 33947	Drawing Revision	: A
		Material	: <u>N/A</u>
Written By	: <u>JA 08.01.8</u>	Due Date	: 1/18/2008
Checked & Approved By	: <u>JA 08.01.8</u>	Qty:	10 Um: Each
Comment	: Est:A 04.08.24 New issue KJ/JLM Est Rev:B Now on Waterjet 06-11-02 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S080	2024-T3 .080 sheet
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Comment: Qty.: 1.9177 sf(s)/Unit Total : 19.1772 sf(s)  
 Material: 2024-T3 (QQ-A-250/4) 0.080" thick  
 (M2024T3S.080)  
 Identify for D3293-1  
 Batch: 105411 **IB 8-1-8**

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3293  
 Dwg Rev: A  
 Prog Rev: A

**IB 8-1-8**

2-Deburr if necessary

**IB 8-1-8**

(12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**IB 8-1-8**

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

6 08601 09

(412)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 08/01/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:38:38 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 36634

Part Number: D32931

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
1- Debur

*nlr Done at step 2.2*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Inspected 12x*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Acid etch and Alodine as per QSI 005 4.1

*Fix 08/01/10 12*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

*M 100700*

*BR 08-01-11 15*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M-A 08/01/11 12x*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: ST 211

*AS 08/01/11 12*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/01/11 12*

Job Completion



*u 08/01/11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_



QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

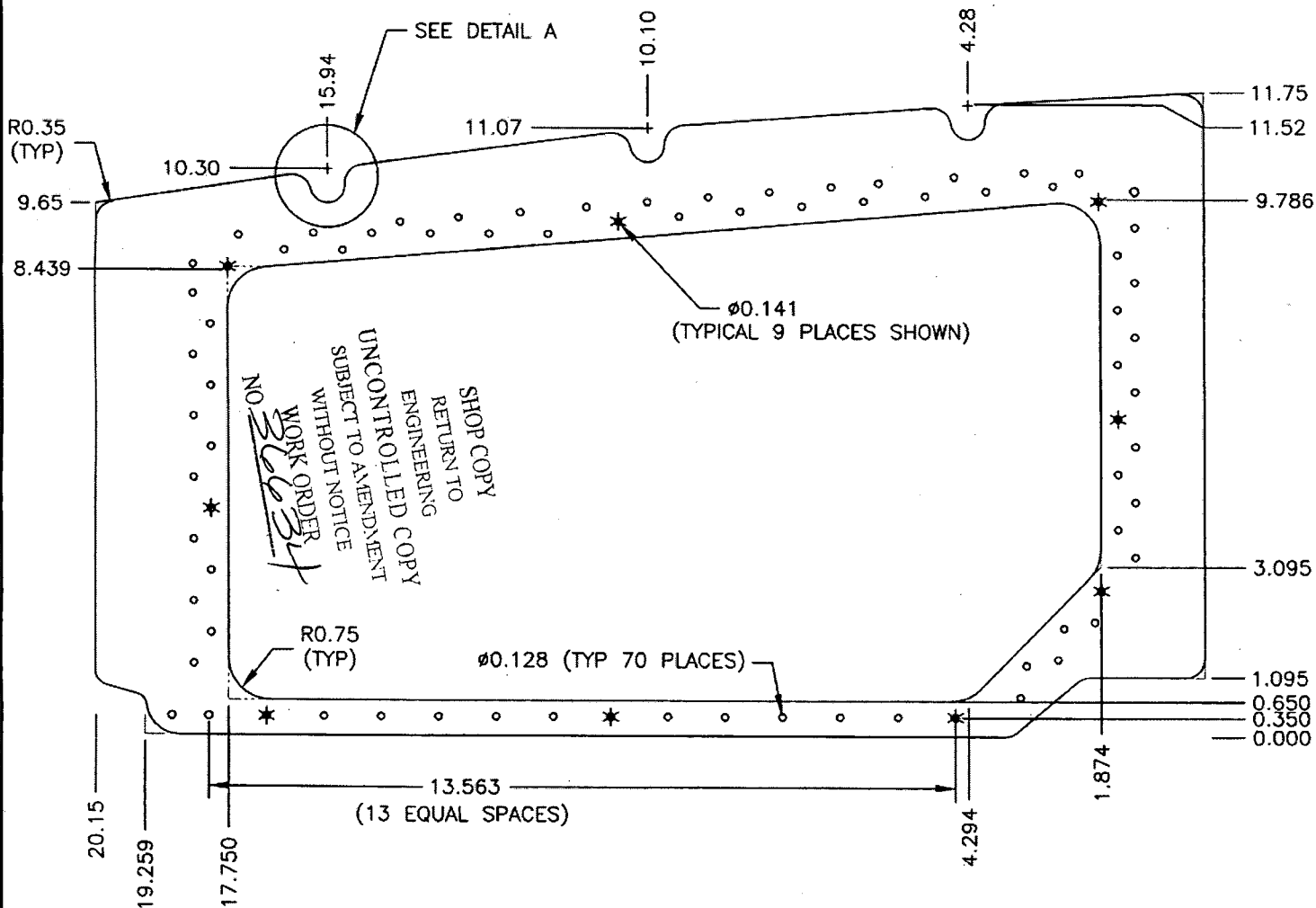
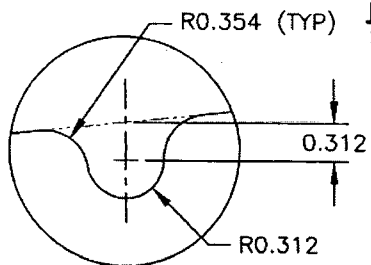


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DESIGN		DRAWN BY		<b>DART AEROSPACE LTD</b> HAMKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. A
DATE				D3293	SHEET 1 OF 1
04.06.28				TITLE	SCALE
				DOUBLER	1:3
A		04.06.28		NEW ISSUE	

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

04.07.12 - #



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